

Work Order ID 58373

May 4, 2010 3:17:30 PM



Page 1

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step

Stop



Start Date: 04/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

BS

Date: 10-5-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP205-633-011 CHG001

S 10/5/10

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10-5-17 (40)

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

S 10/5/10



W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step

Stop



Start Date: 04/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location: <u>70</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Ren G

10-5-18 4x SP

10/05/19

WF 10-5-18

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID: 58373

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments: IPP Rev:F02.07.11 Reformat; Removed D3010 ☐ RF ☐

Start Date: 04/05/2010

Required Date: 13/05/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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AN4-14A Bolt		Purchased	No			110	Each	48.0000	1			
-----------------	--	-----------	----	--	--	-----	------	---------	---	--	--	--

Location	Loc Qty	Loc Code
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ST357	21	
114494	21	
ST358	27	
113359	27	

AN4-5A Bolt		Purchased	No			110	Each	281.0000	2			
----------------	--	-----------	----	--	--	-----	------	----------	---	--	--	--

Location	Loc Qty	Loc Code
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ST356	281	
114108	81	
114330	200	

AN4-6A Bolt		Purchased	No			110	Each	872.0000	2			
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Location	Loc Qty	Loc Code
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ST356	872	
112933	172	
113149	600	
114523	100	

AN4-7A Bolt		Purchased	No			110	Each	232.0000	2			
----------------	--	-----------	----	--	--	-----	------	----------	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST356	232	
113226	232	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID: 58373

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments: IPP Rev:F02.07.11 Reformat; Removed D3010 ☐ RF ☐

Start Date: 04/05/2010

Required Date: 13/05/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

AN5-14A Bolt		Purchased	No			110	Each	85.0000	1		10-5-17	SP
-----------------	--	-----------	----	--	--	-----	------	---------	---	--	---------	----

Location	Loc Qty	Loc Code
ST338	85	
112411	35	
112489	50	

AN5-6A Bolt		Purchased	No			110	Each	57.0000	i		10-5-17	SP
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Location	Loc Qty	Loc Code
ST337	57	
111425	7	
112243	50	

AN960JD416 Washer	NA51149004634	Purchased	No			110	Each	0.0000	15		M114576 10-5-17	SP
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AN960JD516 Washer	NA51149005634	Purchased	No			110	Each	0.0000	4		M113706 SP 10-5-17	
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D2021-101 Eyebolt		Manufactured	No			110	Each	12.0000	1		10-5-17	SP (410)
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Location	Loc Qty	Loc Code
ST004	12	
55021	12	

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 58373

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments: IPP Rev: ☐ 02.07.11 ☐ Reformat; Removed D3010 ☐ RF ☐

Start Date: 04/05/2010

Required Date: 13/05/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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D2022-101 Spacer		Manufactured	No			110	Each	255.0000	2		10-5-17	
---------------------	--	--------------	----	--	--	-----	------	----------	---	--	---------	--

Location	Loc Qty	Loc Code
ST504	255	
45885	55	
50746	100	
52325	100	

D2022-103 Spacer		Manufactured	No			110	Each	146.0000	2		10-5-17	
---------------------	--	--------------	----	--	--	-----	------	----------	---	--	---------	--

Location	Loc Qty	Loc Code
ST004	146	
47964	146	

D2562-001 Strut		Manufactured	No			110	Each	0.0000	1		58280 10-5-17	
--------------------	--	--------------	----	--	--	-----	------	--------	---	--	---------------	--

D2563 Step Weldment Assembly		Manufactured	No			110	Each	0.0000	1		B 58374 10-5-17	
---------------------------------	--	--------------	----	--	--	-----	------	--------	---	--	-----------------	--

D2565-101 Strut		Manufactured	No			110	Each	1.0000	1		1354305 10-5-17	
--------------------	--	--------------	----	--	--	-----	------	--------	---	--	-----------------	--

Location	Loc Qty	Loc Code
ST270	1	
56305	1	

(3) 1358287 10-5-17

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 58373

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments: IPP Rev:F02.07.11 Reformat; Removed D3010 ☐ RF ☐

Start Date: 04/05/2010

Required Date: 13/05/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D2565-103		Manufactured	No			110	Each	3.0000	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	--	--	--

Strut

Location

Loc Qty

Loc Code

ST270

3

56306

3

D2565-105

Manufactured No

110

Each

4.0000

1

Strut

Location

Loc Qty

Loc Code

ST270

4

56307

4

D2565-107

Manufactured No

110

Each

1.0000

1

Strut

Location

Loc Qty

Loc Code

ST270

1

56308

1

D2565-109

Manufactured No

110

Each

4.0000

1

Strut

Location

Loc Qty

Loc Code

ST270

4

54767

3

56309

1

10-5-17 sl
1 B58288 sl

3

10-5-17 sl

4

10-5-17 sl 16
B58220 370 6/10/18

1

10-5-17 sl
3x B58292 sl

1

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 58373

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments: IPP Rev:F002.07.11 Reformat; Removed D3010 ☐ RF ☐

Start Date: 04/05/2010

Required Date: 13/05/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D2565-111 Strut		Manufactured	No			110	Each	1.0000	1			
--------------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--

Location	Loc Qty	Loc Code
ST270	1	
56310	1	

MS21042L4 Nut		Purchased	No			110	Each	2,731.000	8			
------------------	--	-----------	----	--	--	-----	------	-----------	---	--	--	--

Location	Loc Qty	Loc Code
ST139	2	
111827	2	
ST300	2229	
113422	96	
114108	125	
114523	2000	
9063	8	

MS21042L5 Nut		Purchased	No			110	Each	693.0000	2			
------------------	--	-----------	----	--	--	-----	------	----------	---	--	--	--

Location	Loc Qty	Loc Code
ST300	693	
113523	26	
113537	3	
114108	164	
114437	100	
114449	400	

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
1				D205-633-011	Heli-Access-Step™, High Gear
	1			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
			1	D2021-101	EYEBOLT
			2	D2022-101	SPACER
		2	2	D2022-103	SPACER
				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
				D2562-013	STRUT
		1	1	D2563	WELDMENT ASSEMBLY
				D2565-101	STRUT
				D2565-103	STRUT
				D2565-105	STRUT
				D2565-107	STRUT
				D2565-109	STRUT
				D2565-111	STRUT
				D2565-201	STRUT
				D2565-203	STRUT
				D2565-205	STRUT
				D2565-207	STRUT
				D2565-209	STRUT
				D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
				D3165-1	SUPPORT ARM
		1		AN4-7A	EYEBOLT
			2	AN4-5A	BOLT
		3	2	AN4-6A	BOLT
		2	2	AN4-7A	BOLT
			1	AN4-14A	BOLT
				AN4-10A	BOLT
			1	AN5-6A	BOLT
		1	1	AN5-14A	BOLT
	15	15	15	AN960JD416	WASHER
	4	4	4	AN960JD516	WASHER
	8	8	8	MS21042L4	NUT (or MS21042-4) /
	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: B

Date: 07.08.21

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries